












Date: Tuesday, 31/03/2009 1:05:03 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FRONT INBOARD LEG
Job Number	: 46755		
Estimate Number	: 13375		
P.O. Number	:	Part Number	: D37681
This Issue	: 31/03/2009 S.O. No. :	Drawing Number	: D3768 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: A
Previous Run	: 42959	Material	:
Written By	:	Due Date	: 07/04/2009
Checked & Approved By	: <u>JULIE DAWSON 03-31</u>	Qty:	10 Um: Each
Comment	: Est Rev:A 08-06-18 rev.A as per dwg DD verified by:EC Est Rev:B 08-08-25 Rev B Added Drilling tooling JLM Verified By:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w	
			(10X)
Comment: Qty.: 0.8969 f(s)/Unit Total: 3.5876 f(s) 6061T6 TUBE (1.00" x 0.65" wall) batch: <u>M111029 M-109/06/04</u>			
2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			(10X)
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-CUT TUBE TO LENGH AS PER DWG D3768 2-DRILL TUBE USING DT9044 AND AS PER DWG D3768 3-DEBURR <u>M-109/06/04</u>			
3.0	QC5	INSPECT WORK TO CURRENT STEP	
			(10)
Comment: INSPECT WORK TO CURRENT STEP <u>08-06-05</u>			
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
			(10)
Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>FL 09/06/08</u>			
5.0	POWDER COATING	POWDER COATING	
			
Comment: POWDER COATING Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 <u>M102391</u> <u>09-06-18</u> (X10)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FRONT INBOARD LEG

Job Number: 46755

Part Number: D37681

Job Number:



Seq. #:

Machine Or Operation:

Description :

START TIME: 2:00pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:30pm

91 09-06-18 (X10)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(10)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

DK 09-06-18

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(100)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 25A

9/6/22

SD

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/22 AF

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

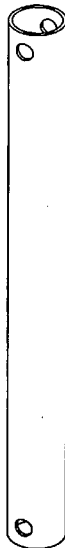
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D3768-1 FRONT INBOARD LEG



D3768-3 FRONT OUTBOARD LEG, LH



D3768-4 FRONT OUTBOARD LEG, RH

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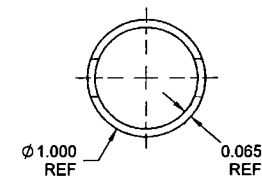
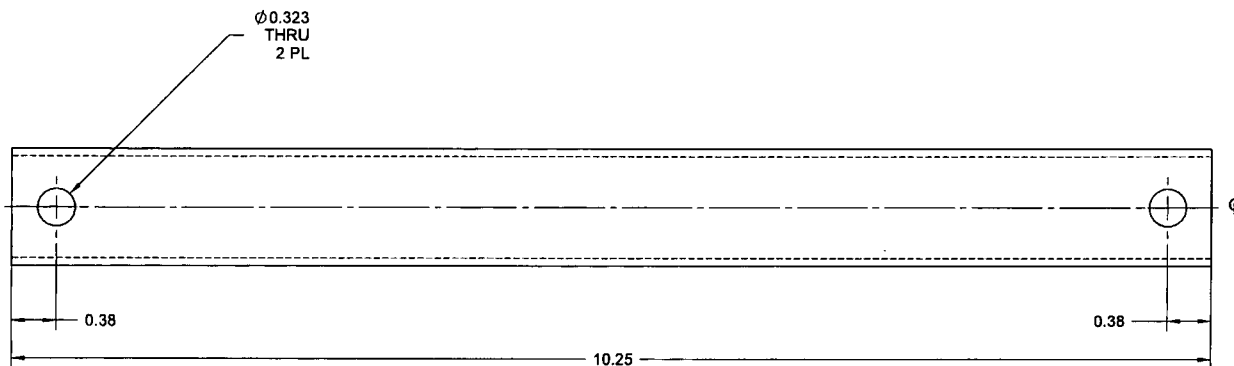
- NOTES:
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" OD X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.00W.065)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "FIRE RED" (4.3.5.10) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.19 lbs

A		NEW ISSUE		HS	08.06.04
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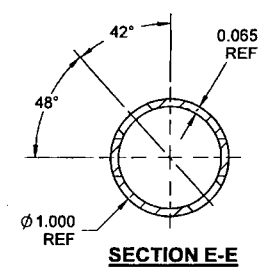
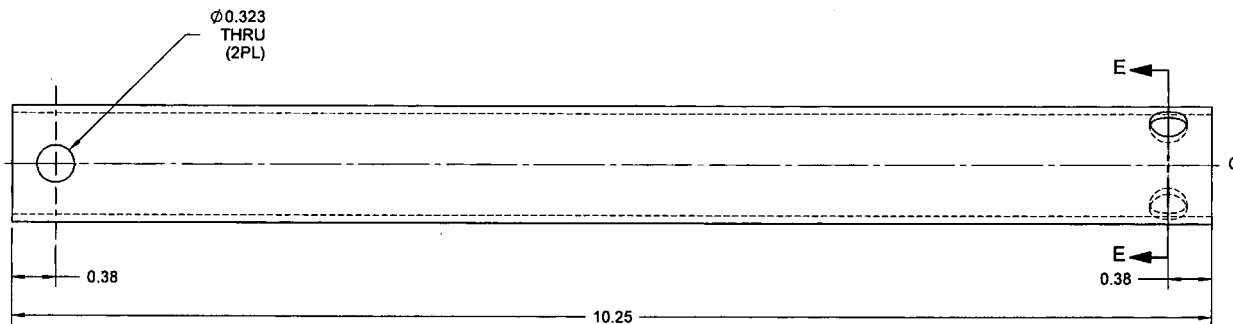


D3768-1 FRONT INBOARD LEG

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D3768-3 FRONT OUTBOARD LEG, LH

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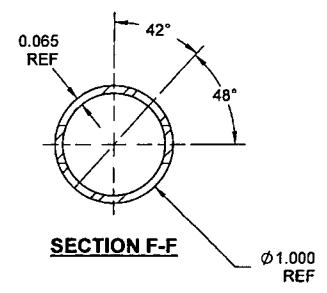
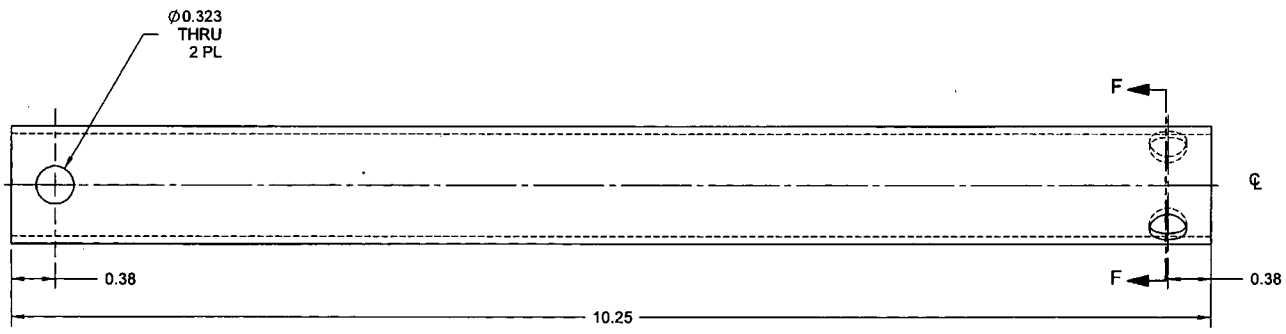
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D3768-4 FRONT OUTBOARD LEG, RH

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